

# Work Order ID 83513

**\*83513\***

Page 1

Thursday, April 19, 2012 10:26:44 AM

Item ID: D3370-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Pedal Lock Base  
 Start Date: 4/19/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 4/27/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: *P* Date: *12-04-19* Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3370	Rev C								

100 Hardinge CNC LATHE SMALL 0.00  
**\*100\*** *ok 12/06/29* 5 *10*  
 Hardinge Memo 0.00  
 Hardinge CNC Lathe Small Machine D3370-1 as per Folio FA499 and Dwg D3370 Identify as D3370-1  
 1Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\*** *ok 12/06/29* 5 *0*  
 QC Memo 0.00  
 Quality Control

120 QC8- Inspect parts - second check 0.00  
**\*120\*** *S.A 12/06/30* 5 *0*  
 QC Memo 0.00  
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
140	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
<b>*140*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:45 OVEN TEMPERATURE:								
	FINISH TIME: 3:20 P								
		4:15							
150	Identify as per dwg & Stock Location	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									

5 76 12.73

5X 12/07/03

5x 80 12-7-3

**Dart Aerospace Ltd**

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**Work Order ID 83513****\*83513\***

Page 3

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Start Date: 4/19/2012      Start Qty: 4.00      **\*4\***      Cust Item ID:  
Required Date: 4/27/2012      Req'd Qty: 4.00      **\*4\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/7/4 *[Signature]*

12079

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 19, 2012 10:26:48 AM

Page 1

Work Order ID: 83513

\*83513\*

Parent Item: D3370-1

\*D3370-1\*

Parent Item Name: Pedal Lock Base

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B05.05.25Added Powder CoatKJ/JLM  
IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased		No		100	f	70.9900	0.3483	1.466526			

\*M6061T6B1 500X02 500\*

\*\*

6061-T6 Bar 1.50 x 2.50

Location	Loc Qty	Loc Code
MAT004	70.99	
103069	12	
→ 107387	22.99	
16742	36	

1.84

on 12/06/28

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	83513
<b>Description:</b> Pedal Lock Base		<b>Part Number:</b>	D3370-1
<b>Inspection Dwg:</b> D3370	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	—		Vernier	
0.202	+/-0.010	.200	—		"	
0.592	+/-0.010	.590	—		"	
0.550	+/-0.010	.558	—		"	
0.760	+/-0.010	.769	—		"	
1.50	+/-0.030	1.500	—		"	
1.188	+/-0.010	1.190	—		"	
1.232	+/-0.010	1.232	—		"	
R0.500	+/-0.010	R.500	—		"	
2.35	+/-0.030	2.350	—		"	
1.920	+/-0.010	1.919	—		"	
0.450	+/-0.010	.449	—		"	
1.673	+/-0.010	1.671	—		"	
2.638	+/-0.010	2.636	—		"	
4.00	+/-0.030	4.000	—		"	
Ø0.203	+0.005/-0.000	Ø.204	—		"	
0.250	+/-0.030	.235	—		"	
1.450	+/-0.005	1.450	—		"	
0.450	+/-0.010	.450	—		"	
15°	+/-0.1°	15°	—		"	

<b>Measured by:</b>	amk	<b>Audited by:</b>	D.A.	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12/06/29	<b>Date:</b>	12/06/30	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

C

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
	1	D2728-7	LABEL
	1	D3370-1	BASE
	1	D3370-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83513  
2012-04-19

RELEASED  
08.07.11

C	SHEET 1 ADDED P/L ADDED -041 TO P/L (SEE NCR 254). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.	AJS	08.07.11
B	D3385-3 WAS D3385-1	MB	05.03.22
A	NEW ISSUE	RF	04.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKFSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
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8 7 6 5 4 3 2 1

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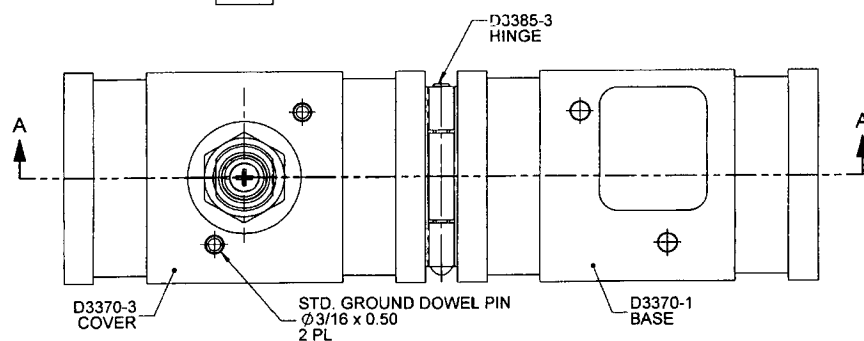
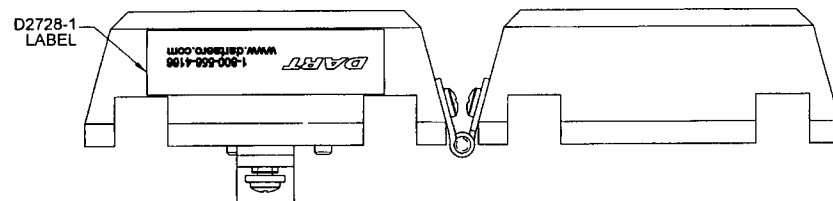
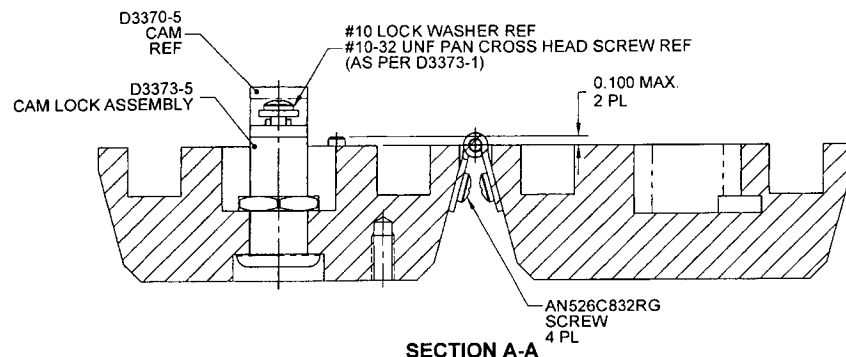
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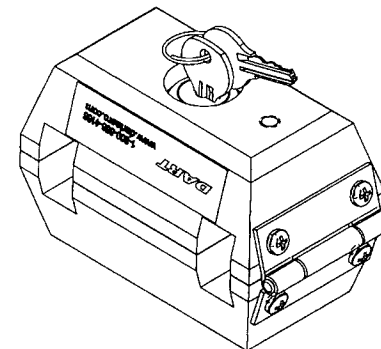
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**NOTE:** Date & initial all entries



**D3370-051 PEDAL LOCK ASSEMBLY**

- NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 0.75 lbs



83513

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08-07-11

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 2 OF 4
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DE APPR.		PEDAL LOCK	NTS
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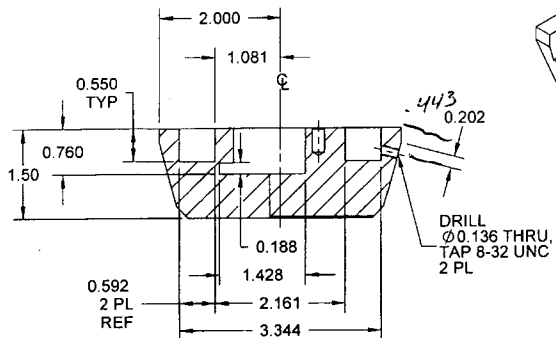
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

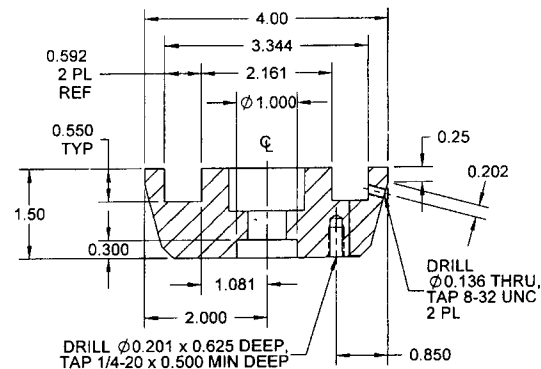
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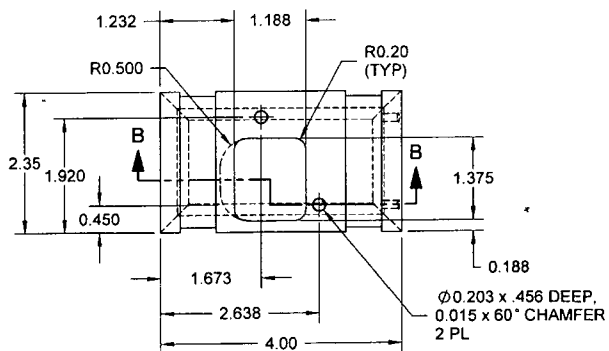
**NOTE:** Date & initial all entries



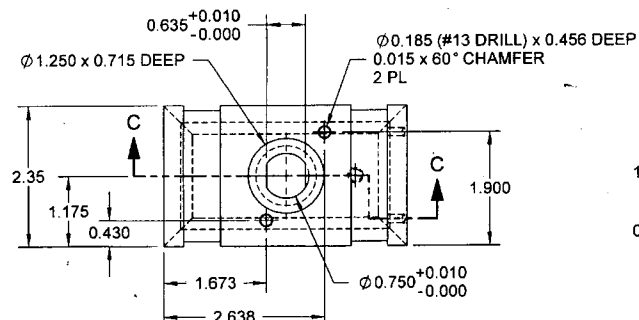
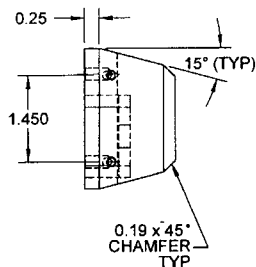
**SECTION B-B**



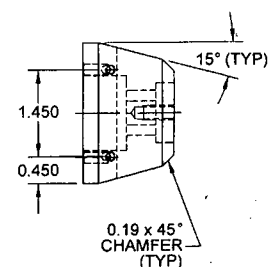
**SECTION C-C**



**D3370-1 BASE**



**D3370-3 COVER**



**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T65
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

83513

**RELEASED**  
08-07-16

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3370</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>PEDAL LOCK</b>	NTS
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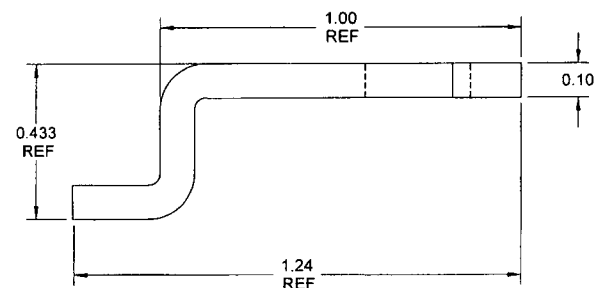
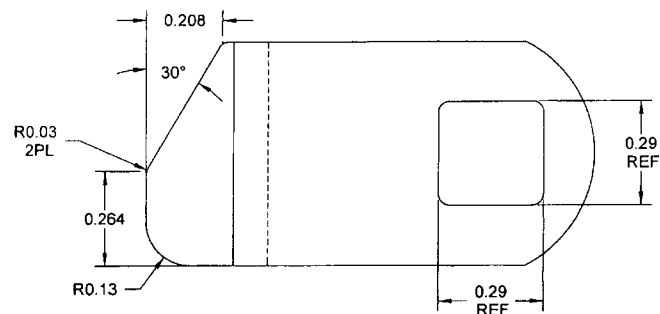
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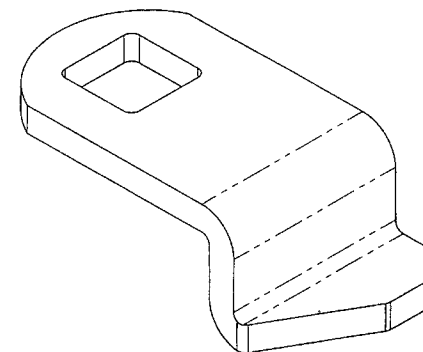
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**NOTE:** Date & initial all entries





**D3370-5 CAM**



88513

**RELEASED**  
780114

- NOTES:**
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
  - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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